Work Order II April-24-14 9:28:04			*117	7084*						Page	1
Item ID: D340 Revision ID: Item Name: Ring Start Date: 4/24/ Required Date: 4/24/ Reference:	/14 Start Qty: 8,00 /14 Req'd Qty;/8.00	( )		*N900 Cust Item I		100	<b>)*</b>	Setup Sta	171	S1* S2*	
	cess Plan: MCJ	Date: 14 04			ate:		· I	Run Sta Sto	<b>^ \</b>	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										-
D3407	Rev E		•								
*100* Waterjet FLOW CNC Waterjet  17-4	FLOW WATER JET  Memo 1-Cut as Dwg Rev Prog Rev		0.00	Debur	~ ~>	PLM	30	6-90	η	DAS 23 9-89	14-06-
	2-Break	edges on manual lathe I	Owg D3407 (175rpm)								

30 0

0.00

0.00

G.

QC2- Inspect parts off machine FAI/FAIB

Memo

110

\*110\* QC

Quality Control

DQA:		Date:											TOART
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UF	PDATE	W	ork Order u	odate only	AEROSPACE
	•				DISPOSITION				AGAINST		PARTMENT,		
Work Orde	r:								AGAINST	—	rantiviciti,		_
					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	o	·			Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	-	Rec/Sto	e/Packaging	Other
NCR N	o				Suspected Unapproved			Large Fab	Composite			Supplier	] []
Root				Desci	ription of work order update		nitial	Acti	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	QC Inspector
Design													
Doc/Data													
quip/Tooling													
Handling/Pre													}
Material													
Operator 🕫 -									· ·				
Offset/Setup.											!		
rocess 🔪 .												!	
Supplier							•						
Training				,									
Fransport	_												
Jnapproved		<u> </u>						ļ					
						FAI	ULT CA	regory					
Landin	g Gear			_	General		1			_	1	_	¬
J. 3	Bending			<u> </u>	Bend	<u> </u>	1 '	rogram	•		Outside Dim	<del>-</del>	Pressure/Forced
,	Centre No	ot Conce	ntric	_	BOM/Route	<u> </u>	Grain			<u> </u>	Over/Under	<u> </u>	Set-up
	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorre	<u> </u>	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave	_	Burrs	┕	1 '	ion Incomplete/Un	•		Part Lost/Mi	ssing	Weld
Ļ	Cuffs				Contamination	_	4	ions Incomplete/U	inclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink		4	ned/off center		<u> </u>	Positioned V		٦.
	Heat Trea			<u> </u>	Cut Too Short		Mislabe				Power Loss/	Surge	Other
-	Inspectio	•	Tube	<u> </u>	Drawing		Misread						
	Marks/Ch				Drill Holes	$\vdash$	Off-set						
1	Turning S				Finish	<u> </u>	4	Calibration					
	Wave/Tw	ist in Tul	e		Fit/Function		Out of	Sequence					

<b>Work Ord</b> April-24-14 9:2		17084		*	1170	84*							Page	2
Item ID: Revision ID:	D3407-5			Accept	*	N900	<u>040</u>	100	)*	Setup		*N	S1*	
Item Name:	Ring										Stop	*N:	S2*	
Start Date:	4/24/14	Start Qty: 8.00		* <u>8</u> *		Cust Item I	D:							
Required Date: Reference:	4/24/14	Req'd Qty: 8.00	7	*8*		Customer:								
Approvals:	Process P	an:	Date:	Toolin	g:	Da	ate:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y	₹/ <b>N):</b>	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Run	Up/ n Hours <sub>D</sub> AS	Tool ID	Tool #	Plan Code	Accep Qty	t Re		Reject Number	Insp. Stamp	
120		QC8- Inspect parts - seco	nd check	0.00	, 27				00-					
*120* QC Quality Control		Memo		0.00	W/w/2	П			30	<i>\$</i> _				-
130	•	Identify as per dwg & Sto	ock Location:	WA501 0.00					0		7	1.1.6	2 2	
*120* Packaging		Memo		0.00					50		H_	14-7	-2_	_
Packaging		*****STOC	K IN LARGE	FAB****										

140

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

14/7/3 A) MF 7-02

DQA:		Date:											•	TOACT
OA Classide		Data			WORK ORDER NON-	-C(	ONFO	RMANCE / UI	PDATE		101		_	AEROSPACE
QA Closed:		Date:								W	ork Order u	odate only		
Work Order					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
				_	Rework	1		Skid-tube	Crosstube		1	Water Jet	$\Box$	Engineering
Part No	) <b>.</b>				Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	$\exists$	Quality
					Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging	$\neg$	Other
NCR No	)				Suspected Unapproved			Large Fab	Composite		]	Supplier		
Root	1	<u> </u>		Descr	ription of work order update		Initial	Act	ion		Sign &	<u> </u>	$\neg$	
Cause	Date	Step	Qty	Desci	or non-conformance	ı	nief Eng		iption		Date	   Verification	,	QC Inspector
Design	1	Осер	~.,		· · · · · · · · · · · · · · · · · · ·	Ci	iici Liig	Desci	iption		Date	Vernication	+	QC IIISPECTOI
Doc/Data	1													
Equip/Tooling	1												ı	
Handling/Pre	1													
Material	1		}		,								ı	
Operator	<b>]</b>			•										
Offset/Setup														
Process														
Supplier														
Training													- {	
Transport	_												}	
Jnapproved	_													
		<u>.</u>			<del></del>	FA	ULT CA	regory						
Landing					General		1				,	-	_	
_	Bending			-	Bend		i i	rogram			Outside Dim	<b>+</b>	_	Pressure/Forced
_	Centre No	ot Concer	ntric	-	BOM/Route		Grain			L	Over/Under	<b>-</b>	_	Set-up
·	Cracks			_	Broken/Damage/Defect		Hardwa			_	Part Incorred	<b>F</b>	$\neg$	Temperature/Cure
ļ <u> </u>	Crimp/Kir	ık/Ripple	/Wave	_ ⊢	Burrs	<u> </u>	1 '	ion Incomplete/Un	•	_	Part Lost/Mi	ssing	_	Weld
<u> </u>	Cuffs			_	Contamination	<u> </u>	4	ions Incomplete/U	inclear	_	Part Moved	<u></u>		Wrong Stock Pulled
<u> </u>	Crushing				Countersink	-	1 "	ned/off center		_	Positioned V		$\neg$	O4h
	Heat Trea		Tuba	$\vdash$	Cut Too Short		Mislabe			Щ	Power Loss/	ourge [	Ц	Other
-	Inspection Marks/Ch	•	rupe	$\vdash$	Drawing Drill Holes		Misread Off-set	ı					—	
-	Turning S			$\vdash$	Finish	$\vdash$	1	Calibration					—	
$\vdash$	Wave/Tw			<del></del>	Fit/Function	_	4	Sequence					—	
	1 ** * * * * * * * * * * * * * * * * *	iii iuk		1	1.19. 0110001	ı	, , , , , , , , , , , , , , , , , , , ,	requeries						

**Picklist Print** 

April-24-14 9:28:08 AM

Work Order ID: 117084

\*117084\*

Parent Item: Parent Item Name: Ring

D3407-5

\*D3407-5\*

**Start Date:** 4/24/14

Required Date: 4/24/14

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 05-11-22 JLM

IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased	No		100	f	46.8300	0.2666	× 8.	ე <del>ე</del>	***	DAS 23
*M174R0	250X4 (	<u>ነ</u> በበ*						**				9-8914

17-4 SS Bar .250 X 4.00

Location	Loc Qty	Loc Code	
MAT049	46.83		
m127719	8.58		
m127866	38.25		
127583			127583

DQA:		. Date:										J	DART
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U		Wo	ork Order up	odate only	AEROSPACE
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
Part N NCR N	0.	-		_	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desci	ription of work order update	Ī	nitial	Act	ion		Sign &	-	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design Coc/Data Doc/Data Doc/D													
* - · · 1° ·						FA	ULT CAT	TEGORY					
Landin	g Gear  Bending  Centre No Cracks  Crimp/Kir  Cuffs  Crushing  Heat Trea Inspection Marks/Ch Turning S	nk/Ripple it n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Ur ions Incomplete/U ned/off center iled			Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ci ssing /rong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
Γ	Wave/Tw	ist in Tuk	e e		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	117084
Description: Tow Ring	Part Number:	D3407-5
Inspection Dwg: D3407 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

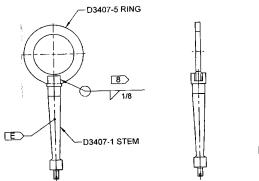
X	First Article		Prototype
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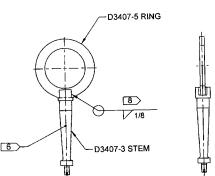
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.260"	-		V	Jtm05
Ø3.000	+/-0.030	3007	-		V	
Ø2.050	+0.012/-0.001	2.054	_			
0.75	+/-0.030	0.750°	-		v	
			-,			
			DAS			

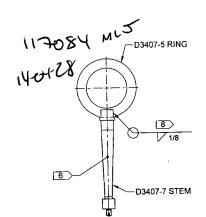
Measured by: 23
9-89
Date: 14-0(-7)

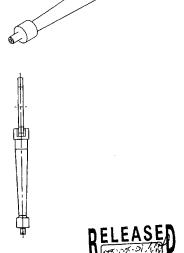
Rev	Date	Change	Revised by	Approved
Α	07.02.02	New Issue	KJ/JLM	
В	07.09.18	Tolerance revised	KJ/EC	
С	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM ,	1
D	09.05.04	Dwg Rev updated	KJ/DD 😾	6/0//

2TY 041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
_^_	x		D3407-043	TOW RING
	_ ~_	Х	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM









D

D3407-041 TOW RING

D3407-043 TOW RING

<u>D3407-045 TOW RING</u> ♠

DE APPR		14	TOW RING		NTS
APPROVED		101	· TITLE		SCALL
MFG. APPR.		(1) d1	D3407		SHEET 1 OF
CHECKED		بسينا	DRAWING NO.		REV. I
DRAWN		Pel	PORT HADLOCK	C, WA	
DESIGN		14)	DART AEROSPAC	E USA	, INC.
REV.	DESCRIPTION			BY	DATE
Α	NEW ISSUE			СР	05.03.16
В	UPDATE DIAMETER, THREAD CLASS ADDED			СР	05.06.17
c	-1/-3 LONGER FOR FIT W/WASHER			CP	05.09.09
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY			РН	08.04.07
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY			PH	08.07.23

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
7) WEIGHT: D3407-041 - 0.60 lbs. D3407-043 - 0.53 lbs. D3407-045 - 0.61 lbs
8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

08.07.23

DE APPR.

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HOT TO BE USED FOR ANY PRIVADES OF CONSISTANCE TO THE OTHER PRIVADION OF CONSISTANCE TO THE OTHER PRIVADION FOR MINISTER A SECOND AS USAS INC.

D

